

Work Order ID 68264

Monday, April 11, 2011 10:13:52 AM

Page 1

Item ID: D3589-5

Accept

Revision ID:

Item Name: LATCH GUIDE

Start Date: 4/11/2011 Start Qty: 4.00

Required Date: 4/13/2011 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3589

Rev B

100

0.00



Hardinge

Hardinge CNC Lathe Small

Memo

0.00

1-TURN AS PER FOLIO FA755 & DWG D3589

FOLIO REV: 13DWG REV: 13

2-DEBURR AS REQUIRED

ml 11.4.12 4

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

ml 11.4.12 4

Picklist Print

Monday, April 11, 2011 10:13:49 AM

Page 1

Work Order ID: 68264

Parent Item: D3589-5

Parent Item Name: LATCH GUIDE



Start Date: 4/11/2011

Required Date: 4/13/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-05-29 new issue DD verified by:EC IPP Rev:B 09-02-20 rev.b asper dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.049		Purchased	No			100	f	210.1605	0.26	1.094737			

304 RD Tube .500 x .049W

Location

MAT017

Loc Qty

210.16053

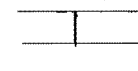
Loc Code

111814

3.23

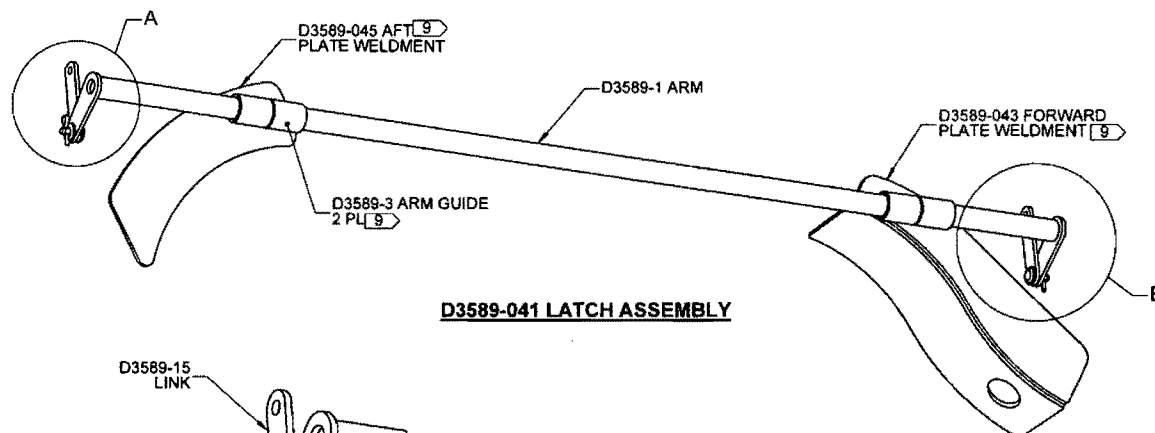
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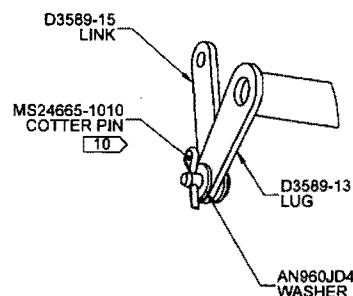


11-4-12

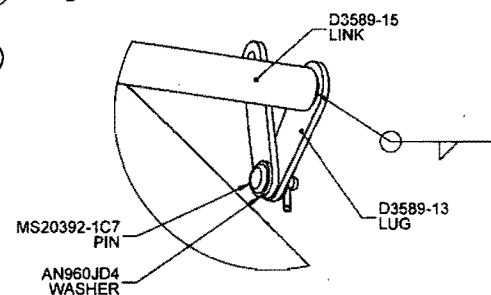
QTY. -041	P/N	DESCRIPTION
X	D3589-041	LATCH ASSEMBLY
1	D3589-045	AFT PLATE WELDMENT
1	D3589-043	FORWARD PLATE WELDMENT
1	D3589-1	ARM
2	D3589-3	ARM GUIDE
2	D3589-13	LUG
2	D3589-15	LINK
4	AN960JD4	WASHER
2	MS20392-1C7	PIN
2	MS24665-1010	COTTER PIN



D3589-041 LATCH ASSEMBLY



DETAIL A: LINK ASSEMBLY DETAIL
SCALE 2X
2 PL



**DETAIL B: WELDING AND
LINK ASSEMBLY DETAIL**
SCALE 2X
2 PL

RELEASED
9/6/05/11/1

B	0.90 AND 0.63 REF WERE 1.97 AND 0.60 (ZN C8-2); 0.50 WAS 1.89 (ZN C3-2); 0.75 REF REPLACES 2.01 (ZN C2-2); 28" WAS 15" (ZN B2-2); 19.00 WAS 18.88 (ZN D4-4); REDESIGNED D3589-8 (ZN A6-6) AND D3589-11F (ZN C2-3) REASON: REDESIGN FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION	MB	08.06.25
A	NEW ISSUE	MB	08.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.25		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3589** REV. B
SHEET 1 OF 8

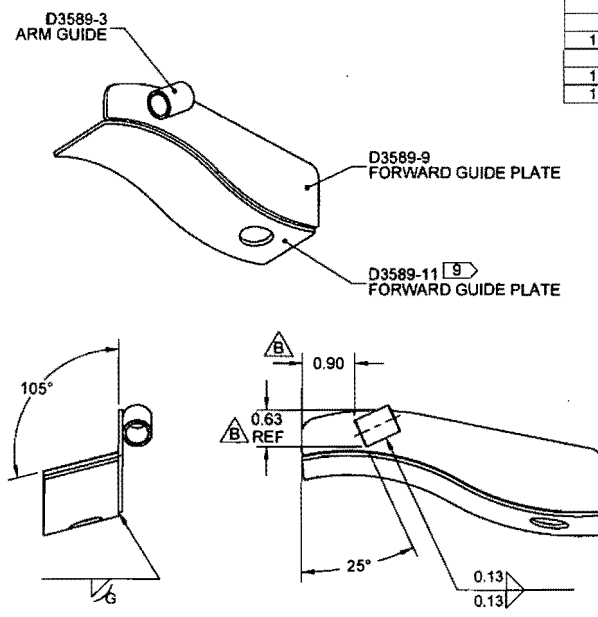
TITLE **LATCH ASSEMBLY** SCALE NTS

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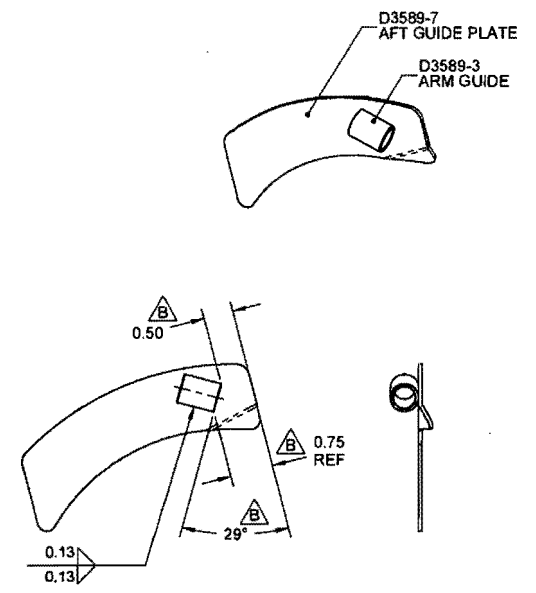
- D3589-041 NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.73 lbs
 - 8) WELDING: PER DART QSI 004 USING DT9033
 - 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
 - 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

WLB 68264

QTY -043	QTY -045	P/N	DESCRIPTION
X		D3589-043	FORWARD PLATE WELDMENT
	X	D3589-045	AFT PLATE WELDMENT
1	1	D3589-3	ARM GUIDE
1	1	D3589-7	AFT GUIDE PLATE
1		D3589-9	FORWARD GUIDE PLATE
1		D3589-11	FORWARD GUIDE PLATE



D3589-043 FORWARD PLATE WELDMENT



D3589-045 AFT PLATE WELDMENT

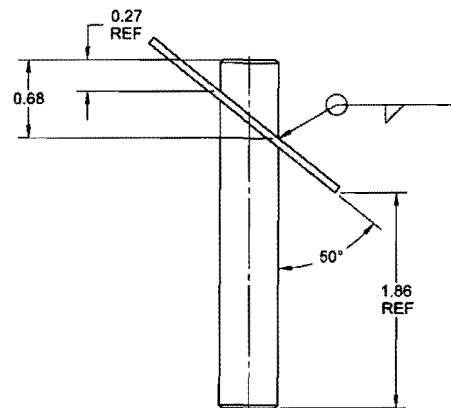
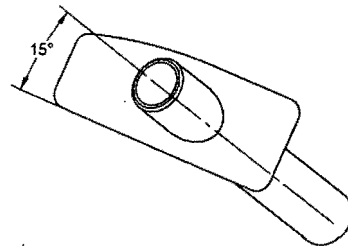
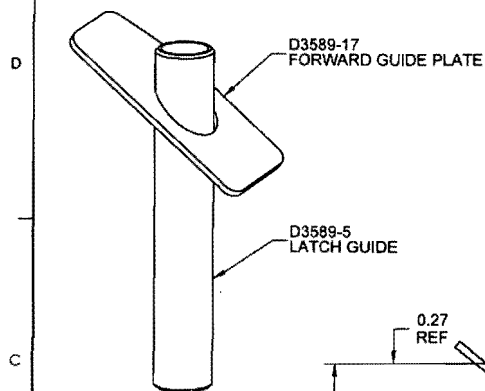
- D3589-043/-045 NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT:
 - D3589-043 = 0.22 lbs
 - D3589-045 = 0.10 lbs
 - 8) WELDING: PER DART QSI 004 USING DT9033
 - 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

68264

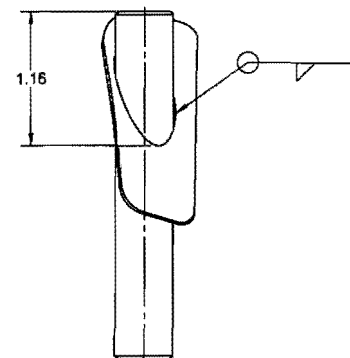
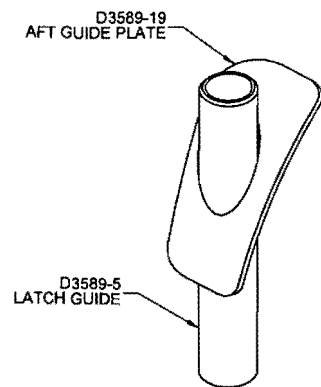
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09/07/05

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 2 OF 8
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DE APPR.		LATCH ASSEMBLY	NTS
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QTY -047	QTY -049	P/N	DESCRIPTION
X		D3589-047	FORWARD GUIDE
	X	D3589-049	AFT GUIDE
1	1	D3589-5	LATCH GUIDE
1		D3589-17	FORWARD GUIDE PLATE
	1	D3589-19	AFT GUIDE PLATE



D3589-047 FORWARD GUIDE



D3589-049 AFT GUIDE

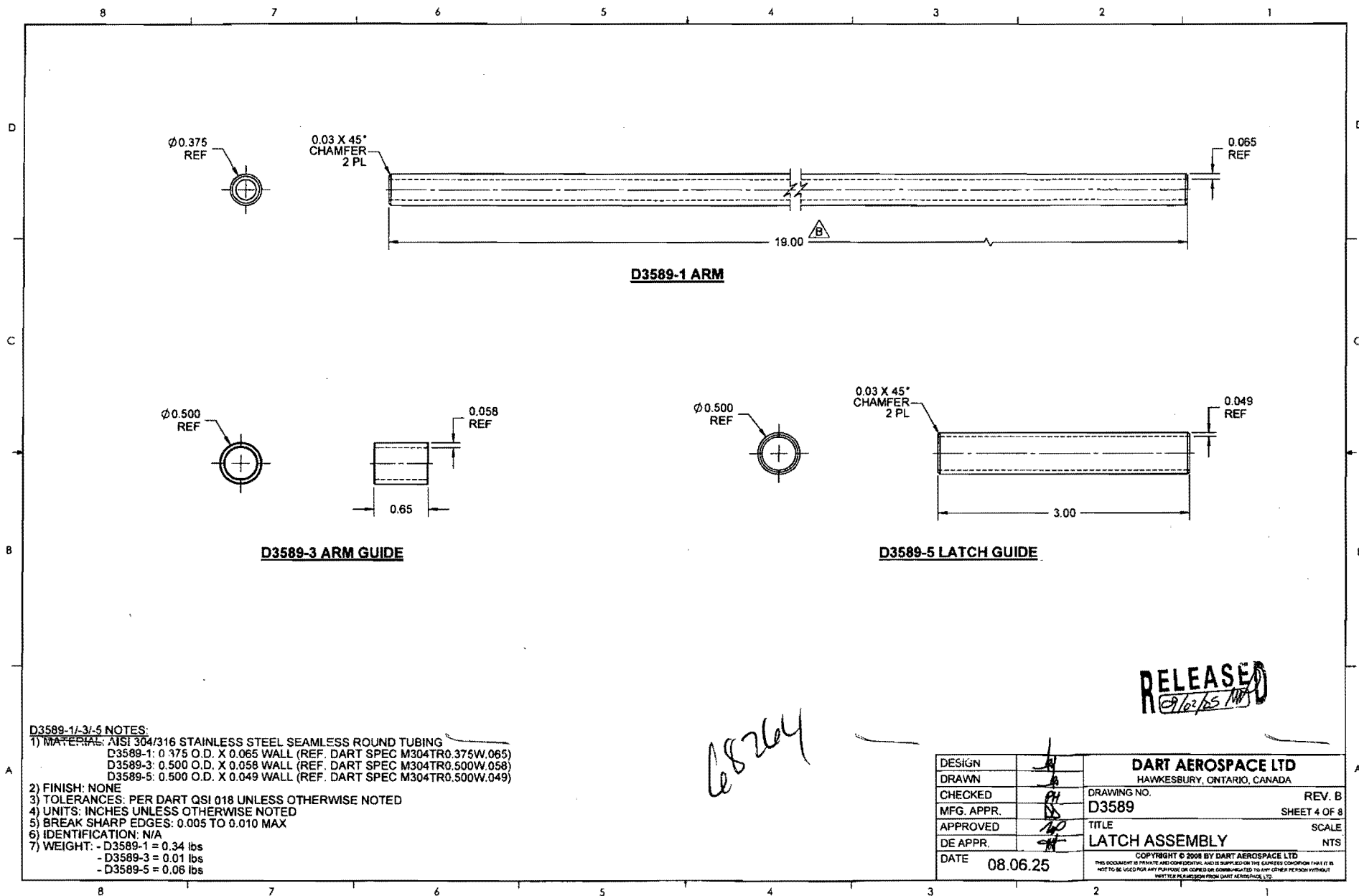
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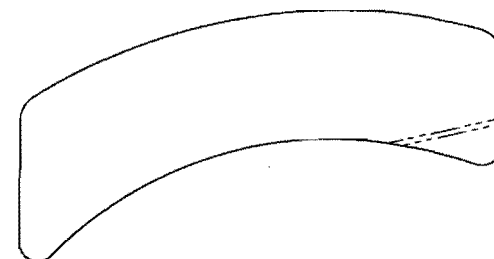
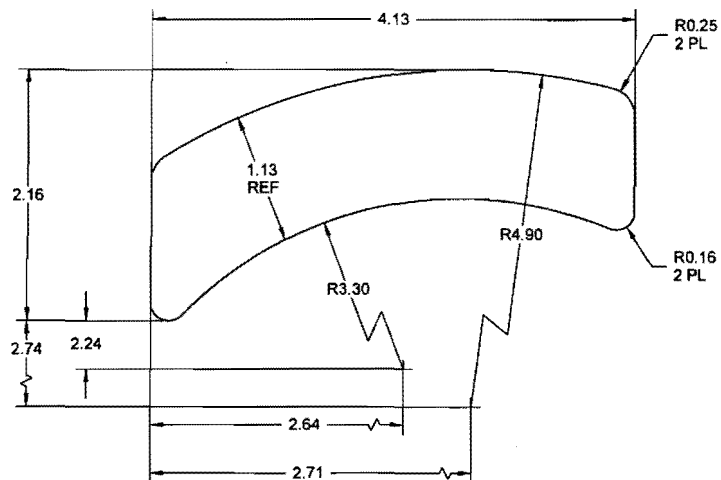
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs EACH
- 8) WELDING: PER DART QSI 004

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DATE	08.06.25	

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08264





D3589-7 AFT GUIDE PLATE
MAKE FROM D3589-7F

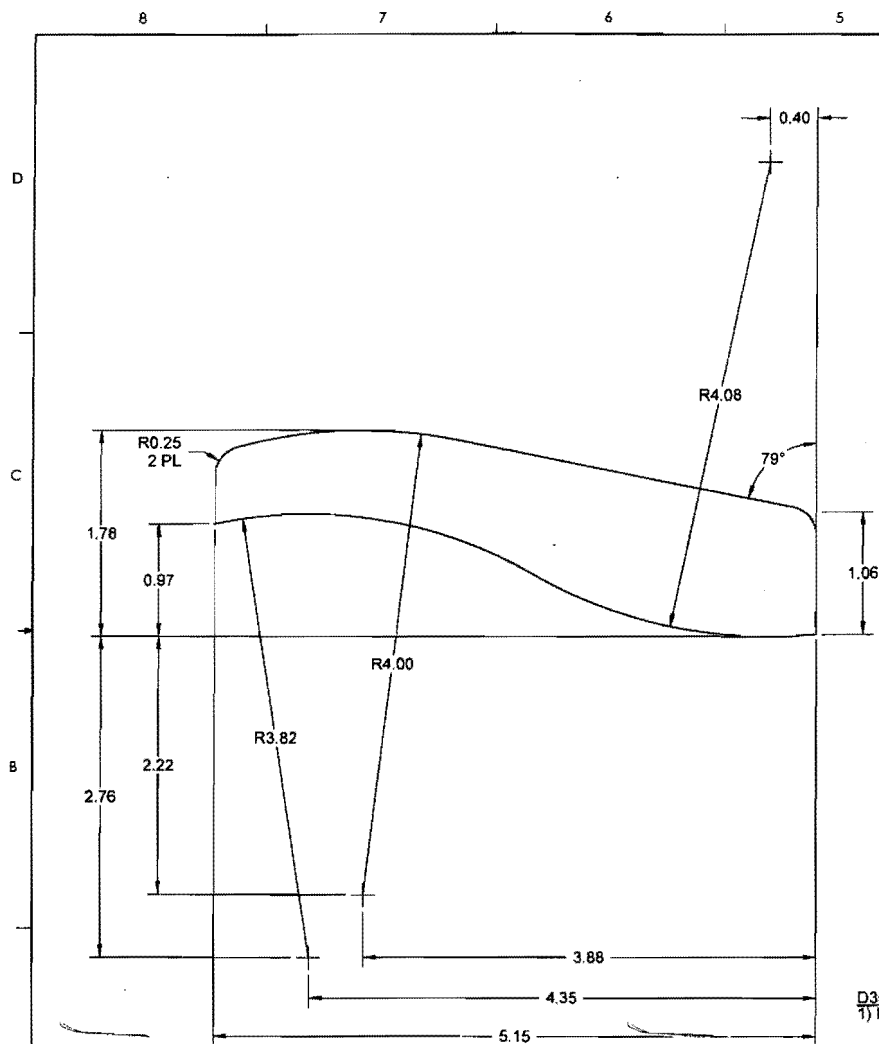
D3589-7F AFT GUIDE PLATE
FLAT PATTERN

RELEASED
09/22/05

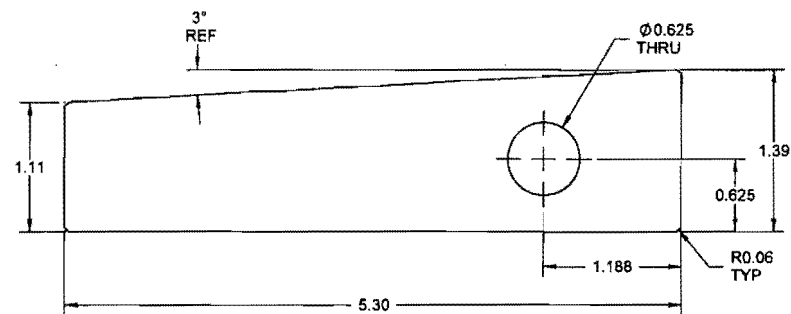
D3589-7F-7F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

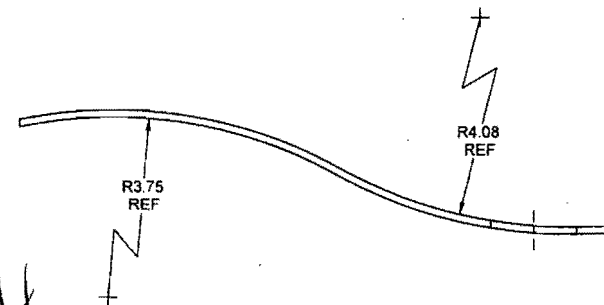
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DRAWN	JH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	SS	D3589	SHEET 5 OF 8
APPROVED	JP	TITLE	SCALE
DE APPR.	JH	LATCH ASSEMBLY	NTS
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D3589-9 FORWARD GUIDE PLATE



D3589-11F FORWARD GUIDE PLATE
FLAT PATTERN



D3589-11 FORWARD GUIDE PLATE
(MAKE FROM D3589-11F)

D3589-9/-11/-11F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET,
PER AMS 5513 OR AMS 5524,
OR MIL-S-5059 (ANNEALED) 2B FINISH
16 GAUGE (0.063 THICK).
(REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs EACH
- 8) CONTROL SHAPE PER DT9021 TEMPLATE

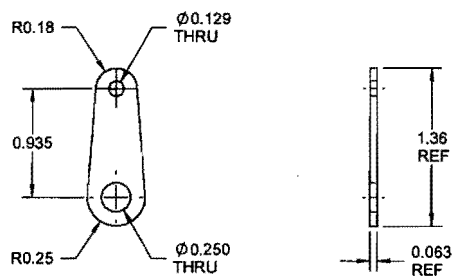
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MFG. APPR.	
APPROVED	
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DATE	08.06.25

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09/26/25

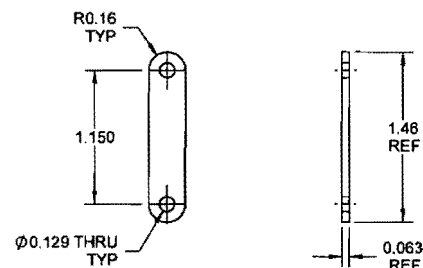
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HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3589** REV. B
SHEET 6 OF 8
TITLE **FORWARD GUIDE PLATE** SCALE NTS

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D3589-13 LUG



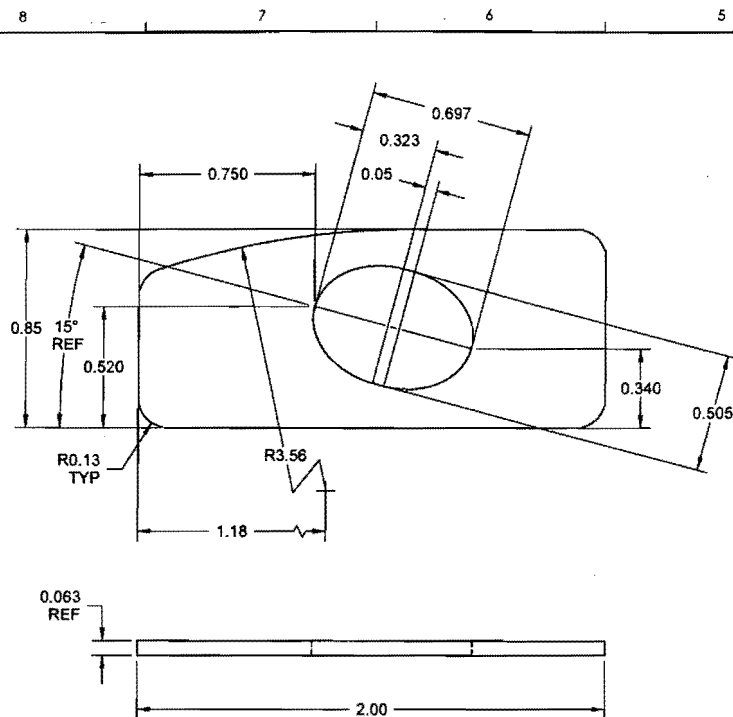
D3589-15 LINK

D3589-13/-15 NOTES:

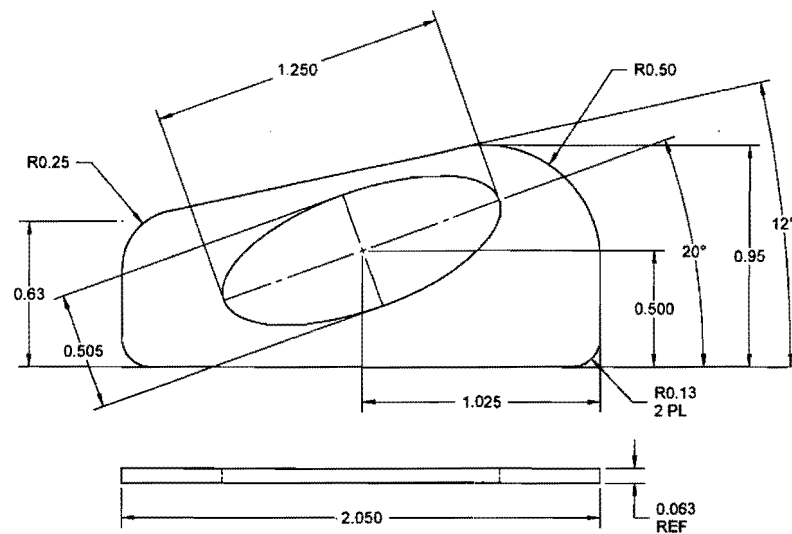
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16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs EACH

RELEASED
07/04/05

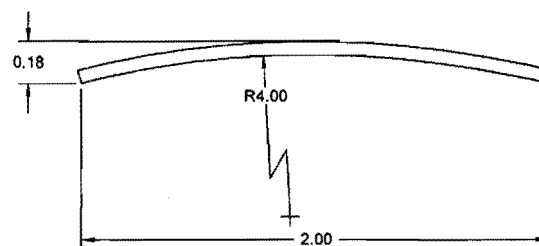
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D3589-17 FORWARD GUIDE PLATE



D3589-19F AFT GUIDE PLATE FLAT PATTERN



D3589-19 AFT GUIDE PLATE
(MAKE FROM D3589-19F)

RELEASED
09/22/85/118

D3589-17/-19/-19F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH
16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs EACH

68264

DESIGN	J
DRAWN	J
CHECKED	PH
MFG. APPR.	SS
APPROVED	140
DE APPR.	14
DATE	08.06.25

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3589** REV. B
SHEET 8 OF 8
TITLE **LATCH ASSEMBLY** SCALE NTS

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